

19-7786



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200
Fax 613 632-5246

012952

D350-591-121
Job Sheet 200544-A



Part No: D350-591-121

Job Qty: 1 pcs

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/8/19

Job Tracking No:

Due Date: 11/12/19

Created By: Eric Larocque

Type: Stock

Description:

Note: DWG IIN-D350-591 REV.I, D2351-041 REV E IPP Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP KJ/RF IPP rev. F 06.02.23 added grinding EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
122	QC 5	3 pcs	11/12/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
140	Large Fab - Steps - 2 - B4B	3 pcs	11/12/19		0.00	2.04	Large Fab - 1 - B4B		[Signature]
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
							Large Fab - 11 - B4B (Various)		



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Container No: S229981



Part: D350-591-121
Job No: 200544-A
Serial No/Batch: S229646

Revision: I, E

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11 of 11 FAA STC SH96

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150	QC 9	3 pcs	11/12/19	0.00 0.00	QC 9 - 10	
					QC 9 - 18	
					QC 9 - 24	
					QC 9 - 43	
					QC 9 - 50	
					QC 9 - 9	2
160	QC 5	3 pcs	11/12/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	2
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170	Handfinish - 1-1 Chemical-B4B	3 pcs	11/12/19	0.00 0.56	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	NOV 11 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
180	QC 7	3 pcs	11/12/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	DAS
					QC 7 - 17	81
					QC 7 - 18	9-89
					QC 7 - 19	NOV 11 2019
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	

					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
190	Large Fab - Steps - 3 - B4B	3 pcs	11/12/19	0.00 2.04	Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B	
					(Various)	
220	QC 10	3 pcs	11/12/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
240	Handfinish - 1-2- Chemical-B4B	3 pcs	11/12/19	0.00 0.56	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	

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DAS
24
9-89

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SEB 19-11-12

					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
11211886	250 Powdercoat - 1 White Gl(A)- B4B	3 pcs	11/12/19	0.00 0.49	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
START J: -150V.T: 820° FINISH: 215	260 Handfinish - 3-1- WingWalk- B4B	3 pcs	11/12/19	0.00 0.56	Handfinish - 3 - 1 - B4B	BL 19-11-12
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
	270 QC 3	3 pcs	11/12/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
	280 Packaging 1-1 - Pick Kit - B4B	3 pcs	11/12/19	0.00 0.00	Packaging 1 - 1 - B4B	
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	

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NOV 1 2019 40
9-89

DAS
74
9-89

NOV 15 2019

						Packaging 1 - 8 - B4B	
						Packaging 1 - 9 - B4B	
						Packaging 1 - 10 - B4B	
						Packaging 1 - 11 - B4B	
						Packaging 1 - 12 - B4B	
						Packaging 1 - 13 - B4B	
						Packaging 1 - 14 - B4B	
						Packaging 1 - 15 - B4B	
						Packaging 1 - 16 - B4B	
						Packaging 1 - 17 - B4B	
						Packaging 1 - 18 - B4B	
						Packaging 1 - 19 - B4B	
						Packaging 1 - 20 - B4B	
						Packaging 1 - 21 - B4B	
						Packaging 1 - 22 - B4B	
						Packaging 1 - 23 - B4B	
						Packaging 1 - 24 - B4B	
						Packaging 1 - 25 - B4B	
						Packaging 1 - 26 - B4B	
						Packaging 1 - 27 - B4B	
						Packaging 1 - 28 - B4B	
						Packaging 1 - 29 - B4B	
						Packaging 1 - 30 - B4B	
						Packaging 1 - 31 - B4B	
						Packaging 1 - 32 - B4B	
						Packaging 1 - 33 - B4B	
						Packaging 1 - 34 - B4B	
						Packaging 1 - 35 - B4B	
						Packaging 1 - 36 - B4B	
290	QC 4	3	11/12/19	0.00	0.00	QC 4 - 28	
		pcs				QC 4 - 58	
						QC 4 - 69	
						QC 4 - 9	
						QC 4 - 46	
						QC 4 - 68	
						QC 4 - 72	
						QC 4 - 74	
						QC 4 - 75	
							DAS 78 9-89
300	Packaging 3-1 - Stock - B4B	3	11/12/19	0.00	0.00	Packaging 3 - 1 - B4B	NOV 21 2019
		pcs				Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
							Plex 11/8/19 7:57 AM dart.larocque.eric

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NOV 21 2019

				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	DAS
				Packaging 3 - 25 - B4B	78
				Packaging 3 - 26 - B4B	9-89
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
305 DC - 1 - B4B	3	11/12/19	0.00 0.00	DC - 1 - B4B	21
	pcs			DC - 2 - B4B	9-89
310 QC 21 - FG	3	11/12/19	0.00 0.00	QC 21 - FG - 21	NOV 21 2019
	pcs			QC 21 - FG - 70	
				QC 21 - SA - 53	DAS
					21
					9-89
					NOV 21 2019

Part Op 122 - (QC5- Inspect part completeness to step on W/O)

Descriptions: 140 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Bevel Fwd and Aft end for welding 2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033 A/RAluminum Rod _____ 3-Do not Grind Flush

150 - (QC9- Inspect visual per QSI004- Fusion Welds)

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Chemical Conversion Coat per QSI005 4.1)

180 - (QC7-Inspect Chemical Conversion Coat)

190 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Rivet Leg Assembly as per Dwg D2351 2-Weld Fwd End Plate per QSI 004 & Dwg D2351 A/RAluminum Rod _____ 3-Grind end plate flush.

220 - (QC10- Inspect visual per QSI004- ground welds)

230 - (QC5- Inspect part completeness to step on W/O)

240 - (Chemical Conversion Coat per QSI005 4.1)

250 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

260 - (Wing Walk as per dwg QSI005 4.4 Batch 5209364)

270 - (QC3- Inspect Part Finish)

280 - (Pick Kit)

290 - (QC4- 100% Inspect kits for completeness)

300 - Identify and pack for shipping as per PPP D350-591-121 Location:FG039

305 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

310 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2850-1	End Bracket	3 pcs (1 ea)	140-Large Fab - Steps - 2 - B4B	① 5133680 / 5199373 ②
D2582	Hi-Skid Step Leg Assembly	3 pcs (1 ea)	190-Large Fab - Steps - 3 - B4B	5210377
D2673-34	End Plate	3 pcs (1 ea)	190-Large Fab - Steps - 3 - B4B	5210705
MS20600-AD4W3	Cherry Rivet	48 Ea (16 ea)	190-Large Fab - Steps - 3 - B4B	5196544
AN3-37A	Bolt	4 6 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5210648
AN4-13A	Bolt	2 3 Ea (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	5228020
AN4-16A	Bolt	4 6 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5228325
D2230-1	Mounting Lug	2 3 pcs (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	5225193
D2230-3	Mounting Lug	2 3 pcs (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	5225226
D2732-030	Rubber Cushion - 3"	2 6 pcs (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5207313
MS21042L3	Nut	4 6 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5218152
MS21042L4	Nut	4 9 Ea (3 ea)	280-Packaging 1-1 - Pick Kit - B4B	5225610
NAS1149D0363J	Washer	8 12 Ea (4 ea)	280-Packaging 1-1 - Pick Kit - B4B	5228336
NAS1149D0463J	Washer	4 18 Ea (6 ea)	280-Packaging 1-1 - Pick Kit - B4B	5205595

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
140-Large Fab - Steps - 2 - B4B	D2850-1	3	9	0
190-Large Fab - Steps - 3 - B4B	D2582	3	6	0
	D2673-34	3	44	0
	MS20600-AD4W3	48	322	0
280-Packaging 1-1 - Pick Kit - B4B	AN3-37A	6	121	0
	AN4-13A	3	1,867	0
	AN4-16A	6	379	0
	D2230-1	3	146	0
	D2230-3	3	393	0
	D2732-030	6	56	0
	MS21042L3	6	2,602	0
	MS21042L4	9	5,763	0
	NAS1149D0363J	12	1,320	0
	NAS1149D0463J	18	7,696	0
Part Specifications				
Specifications could not be found.				

Entered: JR Date: Dec 30/19



NCR No. 19-7786

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>200544-A</u>		DISPOSITION		DEPARTMENT/PROCESS							
Part No. <u>D350-591-124</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Skid-tube ☒ Machining ☐ Large Fab ☒		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: <u>19.11.14</u>		Sequence #: <u>270</u>		QTY Affected: <u>①</u>				MRB (QSI042) DAS 9 9-89 <u>19.11.14</u>			
Description Work Order Deviation				Disposition				Completed By 4 9-89 <u>19.11.14</u> NOV 1 1 2019			
dent found on top section of step. this was found only after wing wdk but was cause by during the bending.				Scrap destroy / no replace				Lead hand / Supervisor DAS 9 9-89 <u>19.11.14</u>			
								QC / QA Coordinator DAS 9 9-89 <u>19.11.14</u>			
Root Cause		FAULT CATEGORY									
Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		☐ Pressure/Forced ☒ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread									
		Other/Details:									

5.0 PARTS LIST

Qty -117A	Qty -119	Qty -133	Part Number	Description
X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
	X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
		X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1		D2355	STEP ASSEMBLY (LOW-LONG)
		1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
2	2		D2171	CLAMP
2	2		D2182B035	CUSHION
		4	D2230-1	MOUNTING LUG
		4	D2230-3	MOUNTING LUG
4	4		D2274	RADIUS BLOCK
1			D2362-041	SUPPORT BRACKET
	1		D2362-3	SUPPORT BRACKET
		1	D2945	MOUNTING PLATE
1	1		D3595-200-300	CUSHION
		8	D2732-030	CUSHION
	2		AN3-37A	BOLT
		2	AN4-7A	BOLT
		4	AN4-11A	BOLT
		8	AN4-16A	BOLT
	4		AN4-21A	BOLT
4	1		AN4-22A	BOLT
	4		NAS1149D0363J	WASHER (AN960JD10)
4	6	14	NAS1149D0463J	WASHER (AN960JD416)
	2		MS21042L3	NUT
4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
2	2	2	2	D2732-030	CUSHION
2	2	2	2	AN3-37A	BOLT
1	1	1	1	AN4-13A	BOLT
2	2	2	2	AN4-16A	BOLT
4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT



RELEASED
15/12/04

PPP

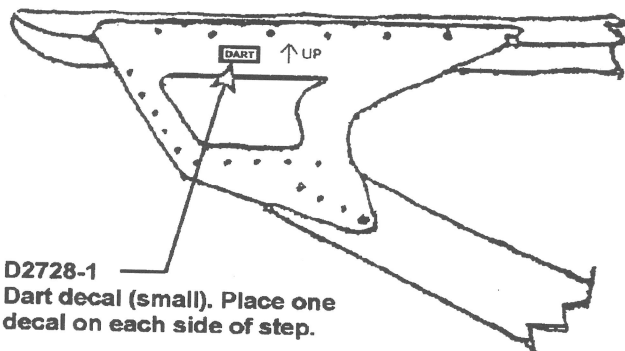
Part Number	D350-591-121
Description	Heli-Access Step, LH High

Box Part Number	MBX104	Dimension	L x W x H 59"
Other Packaging	MF1612	Dimension	MF4612B
Logo Decals	D2728-1		

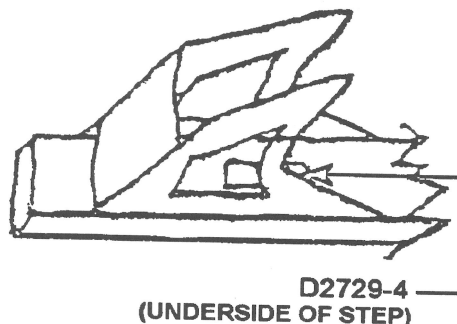
Packaging Instructions and Decal Placement

D350-591-121

Apply label D2729-4 & D2728-1 as per drawing below and ensure Dart label is facing up. Place step in plastic bag. Place MF1612 at each end of box and glue to the interior. Place 2 pcs of MF4612B at each end of box. Place step in box, trim 1/2" off top portions of MF4612B and place to correspond with bottom foam already in place. Place hardware and paperwork in plastic bag, then place packages at end of step. Ensure hardware and paperwork are tightly packaged between end of box and MF4612B. To prevent movement, apply glue to the top pieces of MF4612B. Close box, apply Dart logo tape (always starting at first complete Dart logo) on front flap of box, lengthwise. Apply strapping after first Dart logo, thereafter applying strapping after every second Dart logo. Apply clear tape over strapping. Apply label D2729-3 as per instructions in QSI 014.



D2728-1
Dart decal (small). Place one decal on each side of step.



D2729-4
(UNDERSIDE OF STEP)

D2729-4

D2729-3

DART			
PART NO.	N/A	APPROVED FOR EXPORT BY: [Signature]	
P/N	D350-591-121	QTY	CHG005
DESC	Heli-Access Step, LH High	S/C	SH92-6
LOT	BXXXXXX	S/C	SH967NE
QTY	AS350/355	S/C	
TO APPROVAL: [Signature]		DATE: 15/12/04	



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CANADA
TEL.: 1 613 632-5200

HELI-ACCESS STEP, LH HIGH

P/N: D350-591-121

CHG005

B/N: BXXXXXX

Revision: G

Date: 15.12.04

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